



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-667-207BL
Job Sheet 195393



Part No: D206-667-207BL

Job Qty: 1 pcs

Part Name: Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue



Part Weight: 0 lbs

REV. B

Status: New

Priority: Medium

Job Created: 5/21/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Crosstubes - Bend - 1	1 pcs	6/14/19	6/14/19	0.00	4.35	Crosstubes - Bend		GP 19-05-30.
120	QC 15	1 pcs	6/14/19	6/14/19	0.00	0.00	QC 15 - 12		
							QC 15 - 3		
							QC 15 - 47		
							QC 15 - 49		
							QC 15 - 58		
							QC 15 - 9		
							QC 15 - 68		
130	Crosstubes - 2 - B4B	1 pcs	6/14/19	6/14/19	0.00	2.86	Crosstubes - 1 - B4B		
							Crosstubes - 2 - B4B		BS/6P 19/6/14
							Crosstubes - 3 - B4B		
							Crosstubes - 4 - B4B		
140	Crosstubes - 3 - B4B	1 pcs	6/14/19	6/14/19	0.00	0.55	Crosstubes - 1 - B4B		
							Crosstubes - 2 - B4B		BD 19/6/14
							Crosstubes - 3 - B4B		
							Crosstubes - 4 - B4B		
150	QC 7	1 pcs	6/14/19	6/14/19	0.00	0.00	QC 7 - 10		
							QC 7 - 13		
							QC 7 - 14		
							QC 7 - 15		
							QC 7 - 17		
							QC 7 - 18		
							QC 7 - 19		
							QC 7 - 2		
							QC 7 - 28		
							QC 7 - 3		
							QC 7 - 30		
							QC 7 - 34		
							QC 7 - 36		
							QC 7 - 37		
							QC 7 - 41		
							QC 7 - 47		

Plex 5/21/19 1:29 PM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S185337



Part: D206-667-207BL

Job No: 195393

Serial No/Batch: S185337

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAI

REV. 2

				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	DAS JUN 04 2019 68
				QC 7 - 50	9-89
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
160	QC 5	1 pcs	6/14/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
170	Outsource - 2 - NDT per QSI038	1 pcs	6/14/19		SKY002-VC 1
					2019-06-07
180	Packaging 2-1 - Receive - B4B	1 pcs	6/14/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B

				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
190	QC 5	1 pcs	6/14/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
195	Spray Paint - 2 - B4B	1 pcs	6/14/19	0.00 2.26	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
200	Outsource - 11 - Paint	1 pcs	6/14/19		ATE003-VC
205	Packaging 2-2 - Receive - B4B	1 pcs	6/14/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B

DAS
JUN 10 2019 68
9-89

RD19-6-8

NR DAS
21
NR 9-89

DAS
21
9-89

					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
210	QC 14	1 pcs	6/14/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	AS 19-6-11
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
220	Crosstubes - 4 - B4B	1 pcs	6/14/19	0.00 2.86	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	AS 19-6-11
230	Crosstubes - 5 - B4B	1 pcs	6/14/19	0.00 1.91	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	AS 19-6-11
240	QC 5	1 pcs	6/14/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	JUN 14 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
250	Packaging 1-2 - Pick Kit - B4B	1 pcs	6/14/19	0.00 0.00	Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	JUN 17 2019
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	

				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	1 pcs	6/14/19	0.00 0.00	QC 4 - 28	DAS
				QC 4 - 58	58 MB 06/18/2019
				QC 4 - 69	9-89
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
270 Packaging 3-1 - Stock - B4B	1 pcs	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	58 MB 06/18/2019
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	6/14/19	0.00 0.00	DC - 1 - B4B	DAS 21
				DC - 2 - B4B	9-59 JUN 19 2019
280 QC 21 - FG	1 pcs	6/14/19	0.00 0.00	QC 21 - FG - 21	DAS 21
				QC 21 - FG - 70	9-59 JUN 19 2019
				QC 21 - SA - 53	

Part Op 110 - CNC Alpha 160 Bender - Bend tube as per Dwg D206-667-247 using CNC bender program D206-667-207
 Descriptions: 120 - QC15- Crosstube Dimensional Check

130 - Crosstubes ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED

BY: ***** 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-247. Drill all (3) top holes. Holes facing inboard. Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-247 ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: *****

2- Drill fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-247. Note: FWD side has 3X top holes facing inboard. 3- C'sink holes as per dwg D206-667-247. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes ONLY plug most bottom hole to prevent accidental drilling. Drill holes and ream using drill Jig DT8583 & DT8584 as per Dwg D206-667-247. Drill only the top (2) holes. Drill & ream the top (2) hole

140 - Crosstubes Chemical Conversion ***IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

150 - QC7-Inspect Chemical Conversion Coat

160 - QC5- Inspect part completeness to step on W/O

170 - Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

180 - Receive & Inspect for Damage & Mat'l Certs *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.

190 - QC5- Inspect part completeness to step on W/O *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure results are as per Dwg D206-667-247

195 - Spray Paint / NDT Room

200 - ISSUE PO ***** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY

BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH

W/O _____ **MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per

QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____

PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____

205 - Receive & Inspect for Damage & Mat'l Certs

210 - QC14- Inspect Spray Paint Wrap in plastic bag to protect from scratches ***VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH W/O _____

220 - Crosstubes - 1-Install nut plates as per Dwg D206-667-247.

230 - 1-Abraze mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe 2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: 5176610 exp 10/19 3- Torque bolts as per dwg

240 - QC5- Inspect part completeness to step on W/O ***VERIFY BY _____ BATCH # TO MATCH W/O

***VERIFY BY _____ PART # TO MATCH W/O _____

250 - Pick Kit

260 - QC4- 100% Inspect kits for completeness ***VERIFY BY _____ BATCH # TO MATCH W/O

***VERIFY BY _____ PART # TO MATCH W/O _____

270 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-667-207

Location: _____ PPP Rev: _____

275 - Document Control Photocopy bluefile and create labels as per PPP D206-667-207 chg 002

280 - QC21- Final Inspection - Work Order Release

5154137
5171737
51705156229
410413173359

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D206-667-247TRN	Crosstube Assembly, Mid Aft	1 pcs (1 ea)	110-Crosstubes - Bend - 1	5012 253
D2873-043	Nut Plate Assembly	2 pcs (2 ea)	220-Crosstubes - 4 - B4B	
D2873-045	Nut Plate Assembly	2 pcs (2 ea)	220-Crosstubes - 4 - B4B	
MS20601-AD4W10	Rivet	14 Ea (14 ea)	220-Crosstubes - 4 - B4B	
D2892-1	Support	2 pcs (2 ea)	230-Crosstubes - 5 - B4B	
D3595-063-450	Rubber Cushion 0.63" Wide X 4.50" Long	4 pcs (4 ea)	230-Crosstubes - 5 - B4B	
MS21920-22	Clamp	4 Ea (4 ea)	230-Crosstubes - 5 - B4B	
AN5-10A	Bolt	10 Ea (10 ea)	250-Packaging 1-2 - Pick Kit - B4B	5158586.
AN5-32A	Bolt	4 Ea (4 ea)	250-Packaging 1-2 - Pick Kit - B4B	5058983.
AN5-34A	Bolt	4 Ea (4 ea)	250-Packaging 1-2 - Pick Kit - B4B	5019410
MS21042L5	Nut	4 Ea (4 ea)	250-Packaging 1-2 - Pick Kit - B4B	5181786
NAS1149D0563J	Washer	18 Ea (18 ea)	250-Packaging 1-2 - Pick Kit - B4B	5174288

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Crosstubes - Bend - 1	D206-667-247TRN	1	6	0
220-Crosstubes - 4 - B4B	D2873-043	② 5159731	35	0
	D2873-045	② 5139736	18	0
	MS20601-AD4W10	①⑤ 14 5030491	160	0
230-Crosstubes - 5 - B4B	D2892-1	② 5077374	6	0
	D3595-063-450	④ 517070	49	0
	MS21920-22	⑤ 501728 ③ 4 5162140 ①	96	0
250-Packaging 1-2 - Pick Kit - B4B	AN5-10A	10	178	0
	AN5-32A	4	333	0
	AN5-34A	4	49	0
	MS21042L5	4	813	0
	NAS1149D0563J	18	3,006	0

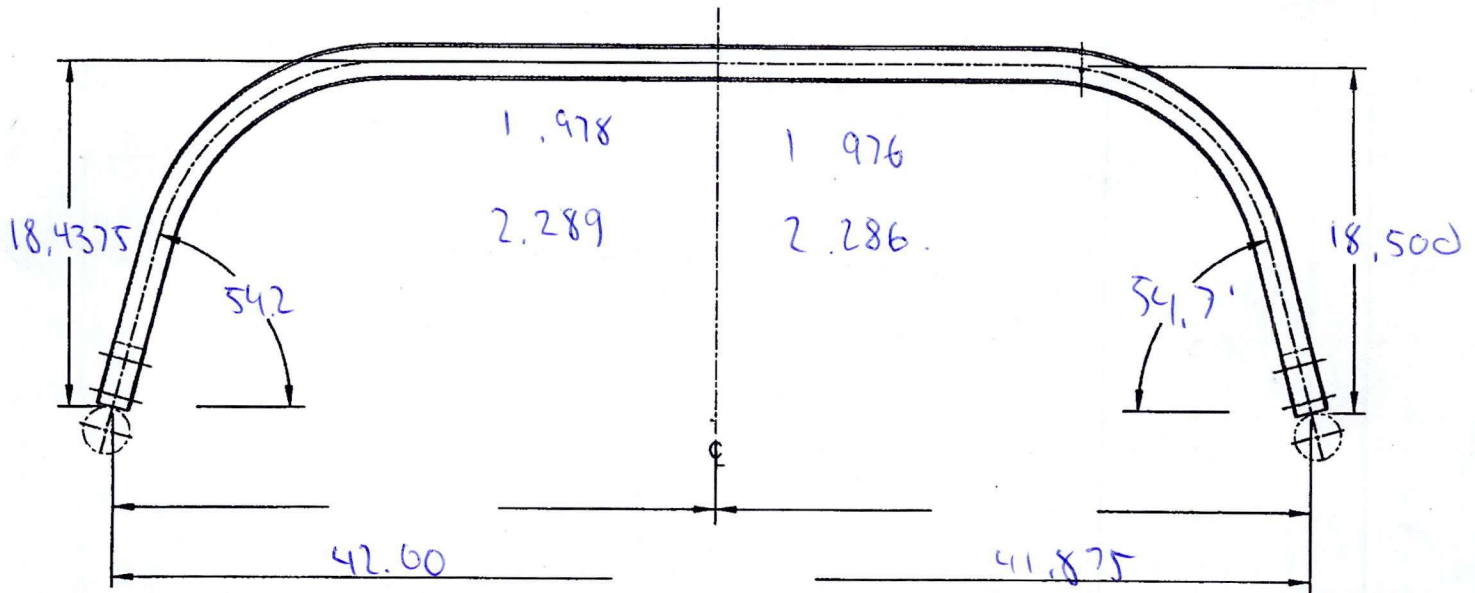
Part Specifications

Specifications could not be found.

Plex 5/21/19 1:29 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	195393
Description: Crosstube Mid Aft (206L)	DAS 35 9-89	Part Number:	D206-667-207
Inspection Dwg: D206-667-247	Rev: A/B		Page 1 of 1

Required Dimension	Min	Max
Height	18.34	18.60
1/2 Span	41.79	42.05
Angle	54°	56°
Total Span	83.59	84.09
Bending Passes	10	--
Crushing	--	6%



	Side A	Side B
Bending Passes	13	13
Crushing	7.2%	7.2%
Comments		
Acceptable per DR-1059		
4/16/13		

QC15 Inspection	
Date	19-05-31

Rev	Date	Change	Revised by	Approved
A	12.02.15	New Issue	KJ	
B	12.04.16	Added bending, crushing dimensions	KJ	

Item	Qty -247	Part Number	Description
1	X	D206-667-247	CROSSTUBE ASSEMBLY (206L MID AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 99.76±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-247" AND BATCH NUMBER ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- WEIGHT: 21.1 lbs (-607 = 17.7 lbs)
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- TO INSTALL D2892-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

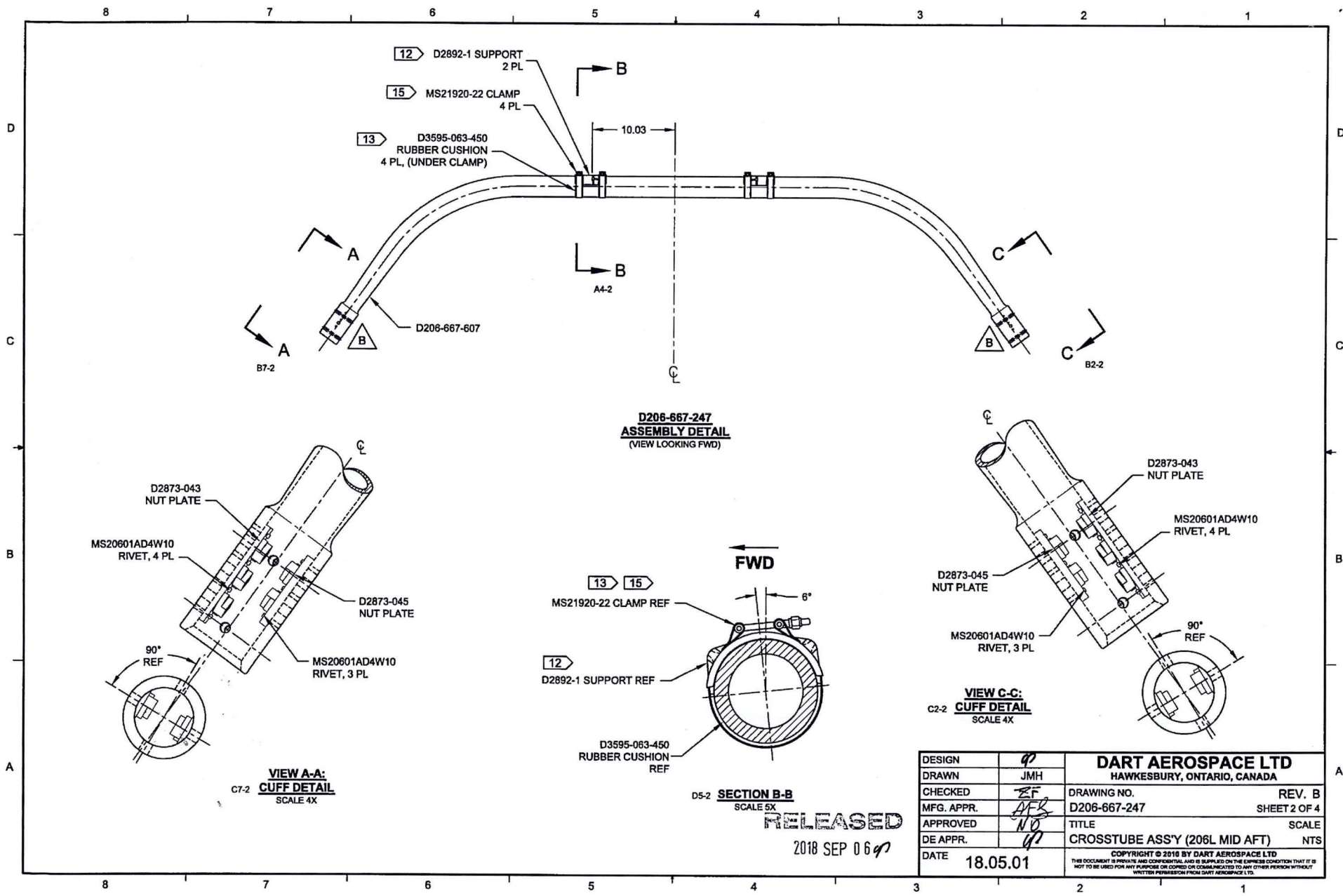
NO. 195393 MJS

19-05-21

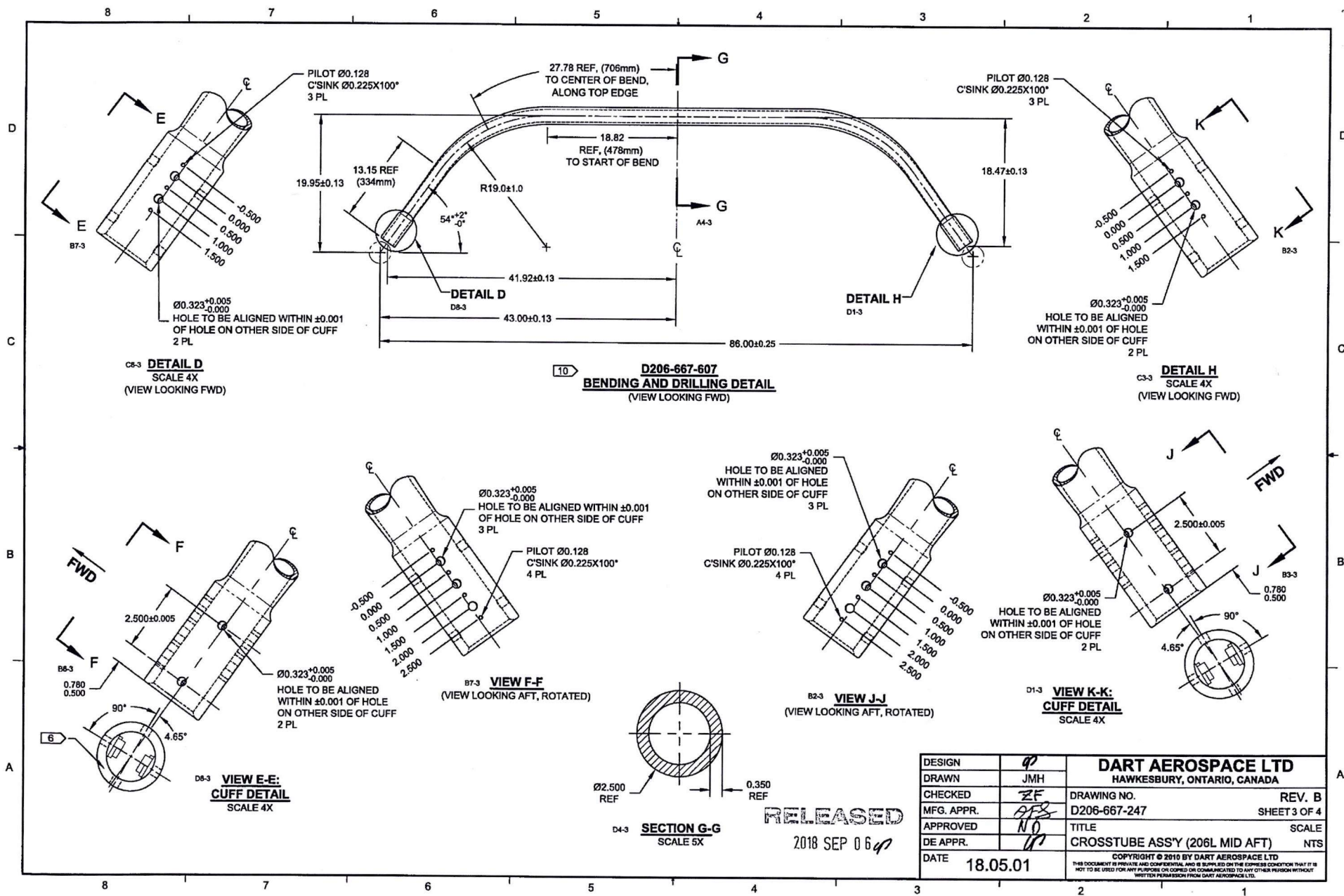
RELEASED

2018 SEP 06
EN 18-777

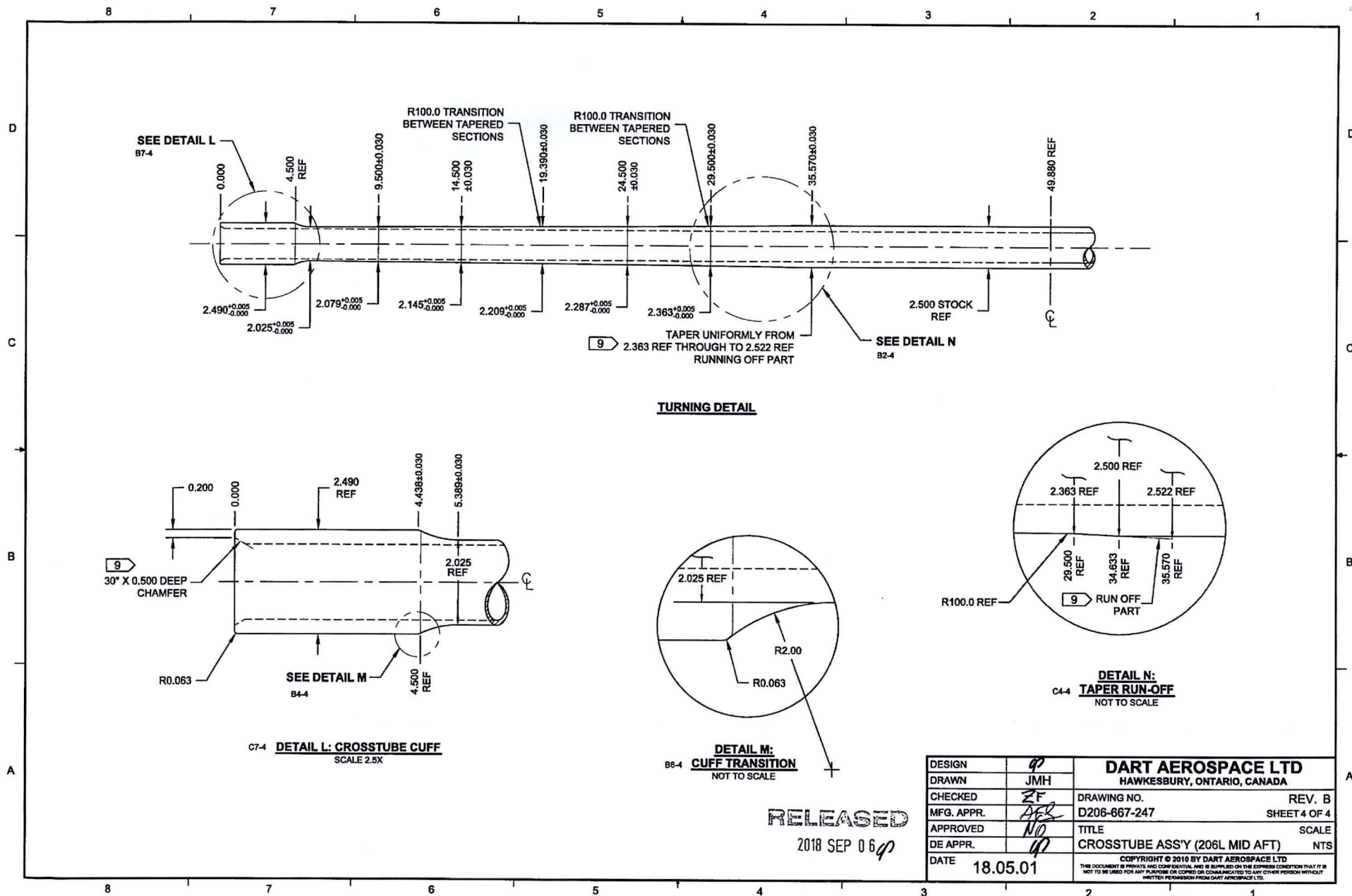
B	REVISE SHEET 2 ASSEMBLY DETAIL HOLE PATTERN PER CAR18-221. UPDATE PARTS LIST AND GENERAL NOTES 12 & 15 TO INCORPORATE DEO A-1.	JMH	18.05.01
A	NEW ISSUE	CP	10.12.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	AFB	D206-667-247	SHEET 1 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (206L MID AFT)	NTS
DATE	18.05.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DESIGN	97	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	EF	DRAWING NO.	REV. B
MFG. APPR.	AFB	D206-667-247	SHEET 2 OF 4
APPROVED	ND	TITLE	SCALE
DE APPR.	97	CROSSTUBE ASSY (206L MID AFT)	NTS
DATE	18.05.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DESIGN	40	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	AFB	D206-667-247	SHEET 3 OF 4
APPROVED	ND	TITLE	SCALE
DE APPR.	DP	CROSSTUBE ASS'Y (206L MID AFT)	NTS
DATE	18.05.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) Completed By Lead hand / Supervisor QC / QA Coordinator	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043652



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043652
PO Date: 6/6/19
Due Date: 6/6/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
kguerin@dartaero.com
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191954	D5610-1TRN	EC130 Aft Crosstube Turning Detail : Various STC's ISSUE P/O: _____	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
2	185902	D412-664-403	412 Stainless Steel Aft Crosstubes - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	185904			Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	185905			Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							3	0	3		\$358.50

3	185904	D412-664-403	412 Stainless Steel Aft Crosstubes - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17	Cancelled	-	6/6/19	0 pcs	0 pcs	0 pcs	\$119.50/pcs	\$0.00
---	--------	--------------	--	-----------	---	--------	-------	-------	-------	--------------	--------



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB043652



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	185905	D412-664-403	412 Stainless Steel Aft Crosstubes - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17	Cancelled	-	6/6/19	0 pcs	0 pcs	0 pcs	\$119.50/pcs	\$0.00
5	195364	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	195366			Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00
6	195366	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Cancelled	-	6/6/19	0 pcs	0 pcs	0 pcs	\$119.50/pcs	\$0.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB043652



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	195393	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
							1 X	JUN 07 2019			
	195394		1 X JUN 07 2019	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00

DAS
68
9-89

8		D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Cancelled	-	6/6/19	0 pcs	0 pcs	0 pcs	\$119.50/pcs	\$0.00
---	--	----------------	---	-----------	---	--------	-------	-------	-------	--------------	--------



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB043652



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	195391	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	195392	1	JUN 07 2019	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00

Grand Total: \$1,195.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/7/19 3:55 PM dart.belanger.natasha



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043652



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043652

PO Date: 6/6/19

Due Date: 6/6/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191954	D5610-1TRN	EC130 Aft Crosstube Turning Detail : Various STC's ISSUE P/O: _____	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
2	185902	D412-664-403	412 Stainless Steel Aft Crosstubes - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
3	185904	D412-664-403	412 Stainless Steel Aft Crosstubes - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
4	185905	D412-664-403	412 Stainless Steel Aft Crosstubes - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043652



Items												
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price	
5	195364	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA- 316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50	
6	195366	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304-07/03/06, DGAC MEXICO STC IA- 316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50	
7	195393	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043652



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	195394	D206-667-207BL	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
9	195391	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
10	195392	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	6/6/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Grand Total:											\$1,195.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB043652



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/7/19 1:49 PM Dart.Guerin.Kimberley

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO40659	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB043652 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 10 CROSSTUBES AS PER POHB043652

2 FWD CROSSTUBES , P/N# D206-667-107BL , J/S# 195391 , 195392

2 AFT CROSSTUBES , P/N# D206-667-207BL , J/S# 195393 , 195394

2 AFT CROSSTUBES , P/N# D212-664-201 , J/S# 195364 , 195366

3 AFT CROSSTUBES (412 STAINLESS STEEL) , P/N# D412-664-403 , J/S# 185902 , 185904 , 185905

1 EC130 AFT CROSSTUBE , P/N# D5610-1TRN , J/S# 191954

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16						JUN 07 2019 DART AEROSPACE LTD.	JUN 06 2019
NO CRACK OR CORROSION FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date: JUN 06 2019
Name: RAFIK MELIKIAN		

5.2 MID-HEIGHT CROSSTUBES

Item	Qty -107	Qty -207	Part Number	Description
	X		D206-667-107	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 MID FWD
		X	D206-667-207	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 MID AFT
7	1		D206-667-147	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 MID FWD
8		1	D206-667-247	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 MID AFT
10	*2		D2891-1	SUPPORT
11		*2	D2892-1	SUPPORT
13	*4		D3595-063-395	RUBBER CUSHION
14		*4	D3595-063-450	RUBBER CUSHION
16	*4		MS21920-20	CLAMP
17		*4	MS21920-22	CLAMP
19	4		AN5-32A	BOLT
20		4	AN5-34A	BOLT
21	4	4	MS21042L5	NUT (OR MS21042-5)
22	8	8	NAS1149C0563J	WASHER (OR AN950JD516)
40	*2	*2	D2873-043	NUT PLATE
41	*2	*2	D2873-045	NUT PLATE
44	10		AN5-7A	BOLT
45		10	AN5-10A	BOLT
46	4		AN5-30A	BOLT
47		4	AN5-32A	BOLT
48	12		AN970-4	WASHER (OPTIONAL)
50	10	10	NAS1149C0563J	WASHER (OR AN960JD516)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-147/-247 ASSEMBLIES ABOVE

PAGE 1 OF 1

Description: CROSSTUBE INSTALLATION, 206L/L1/L3/L4 MID AFT

H:\Forms\Engineer\Approved Eng Online\CHGREC revB